

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006841**Date Inspected:** 18-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG crossbeams**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG cross beam CB1

This QA observed that the contractor has removed this Cross Beam (CB) from the paint bay. No significant work was observed on this CB during the time this QA was present.

OBG cross beam CB3 (in superstructure trial assembly)

This QA observed that the contractor has commenced performing repairs of non compliant weld and base metal discontinuities discovered by Caltrans QA inspectors after grit blasting. The contractors personnel were excavating the defective areas however, no welding was observed during the time this QA was present.

OBG cross beam CB4

This QA observed the contractors personnel grinding the areas where temporary bracing was removed. No other significant work was observed on this crossbeam during the time QA was present.

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OBG cross beam CB5

This QA observed that no significant work was observed on this crossbeam during the time this QA was present.

OBG cross beam CB6

This QA performed random Visual Testing (VT) on this CB. QA was primarily focusing on material discontinuities such as arc strikes, nicks, notches, etc. QA marked a number of areas that exhibited these types of discontinuities to be repaired by the contractor.

This QA observed the contractors personnel grinding and general clean up on this CB. No other significant work was observed on this crossbeam during the time QA was present.

OBG crossbeam CB8

This QA observed that the contractor has commenced fitting and tack welding the floorbeam diaphragms to the side panels on the above mentioned crossbeam in OBG bay 6. No other significant work was observed on this crossbeam during the time this QA was present.

OBG crossbeam CB15

This QA observed ZPMC qualified welding personnel identified as 068250 perform SMAW weld repairs on various weld and base metal discontinuities rejected by ZPMC QC. The repairs were being performed on side panel identified as SP206A. ZPMC QC identified as Mr. Wu Zhi Feng was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-2G (2F)-repair.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

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Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

Inspected By:	Hall,Steven	Quality Assurance Inspector
Reviewed By:	Prue,Erik	QA Reviewer
